

Date: Friday, 11/9/2007 1:19:24 PM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE BILLET (6061)
Job Number	: 35605		
Estimate Number	: 12482		
P.O. Number	: <i>N/A</i>	Part Number	: D6102013
This Issue	: 11/9/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D6102 REV D
First Issue	: <i>NA</i>	Project Number	: N/A
Previous Run	: 33681	Drawing Revision	: D
	Type : PURCHASED PARTS	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/22/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>60</i> Um: Each
Comment	: Est. Rev. A New Issue 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING

Comment: Issue P/O: *5009*

- a) Description: Aluminum Billet
b) 7.000" x 6.500" x 2.000" thick
c) Tolerance on all dimensions is +0.06/0.00
d) Grain direction along 6.500" length
e) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)
Material release certificate is required

*CLO 7/11/09**(60)**[Signature]*

2.0

D6102013P

6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

~~6061-T6 6.0x11.0x5.0~~ *6061-T6 7.00"x6.500"x2.00"**11/12/05*

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Receive & Inspect For Transit Damage
Ensure material certification is attached

[Signature] 7/11/25 (60)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Check certification to Dwg D6102 for compliance

Amk 07/12/05 (60)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Amk 07/12/05 (60)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 05/10/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/9/2007 1:19:25 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET (6061)

Job Number: 35605

Part Number: D6102013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



60

Comment: FINAL INSPECTION/W/O RELEASE

207/12/06

Job Completion



U 8/12-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

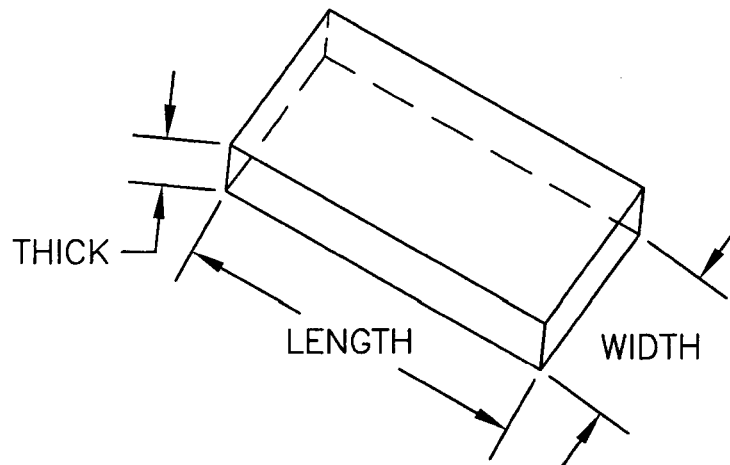
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D6102	Rev. D SHEET 1 OF 1
DATE 06.06.30		TITLE SADDLE BILLET, 6061	SCALE NTS
A	01.03.30	NEW ISSUE	
B	03.10.20	ADD D6102-005/-007/-009	
C	04.08.25	ADD D6102-010/-011	
D	06.06.30	ADD D6102-013	

SPECIFICATION CONTROL DRAWING

**RELEASED**

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6102-001	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.880	6.250	2.000	Along 7.880 Length
D6102-003	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.000	6.250	2.000	Along 6.000 Length
D6102-005	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	47.85	15.250	1.000	Along 47.85 Length
D6102-007	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.500	7.000	2.500	Along 7.500 Length
D6102-009	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	11.000	6.000	5.000	Along 11.000 Length
D6102-010	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	7.950	8.250	2.500	Along 7.950 Length
D6102-011	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	8.250	2.500	Along 6.500 Length
D6102-013	6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8)	6.500	7.000	2.000	Along 6.500 Length

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559429 456208 01

Métaux Castle

A.M. CASTLE & Co. (Canada) Inc.

EXPÉDIÉ 27 NOV 2007 29

RB

QUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPTES-ACCT. VEND. SLS TERR. EXPÉDIÉ PAR-SHIP VIA

EUR-PURCHASING AGENT

TELEPHONE

H/C TAXE

NO. COM. CND

REGION LIVRAISON-DEL ZONE

F.A.B.-F.O.B.

BILL

NO. FEUILLE/EMBALLAGE-B/L NUMBER

NOR LACELLE

613 682-5556

Y

1

C/C

PREPAID

A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

INFORMATION CRÉDIT-CREDIT INFORMATION

ROUTE

01-NL-11/20

31-NL-11/20

CTIONS/LIVRAISON-DELIVERY

Q-K54885

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

PTION - ITEM 1

0000 PLATE 6061-T651 ALUM 7.00" X 6.50"

BLUE

QTE/UNITE COM-ORDERED

10 PCS

PCES/PO COM-ORD

PCS

POIDS COM.-WT. ORDERED

91

BALLOTS-BUNDLES

PCES/PO EXP. S-P

POIDS EXP.-WT. SHIPPED

1

10

91

CERTIFICAT DE CONFORMITE

CONFORMITE

INSTRUCTIONS

See Packing Slip for English Certificate of Conformance

A.M. Castle & Co. (Canada) Inc. certifie que le matériel fourni
prés de ce document rencontrera et est conforme aux
spécifications du produit(s) décrit(s) ci-contre.

A.M. Castle & Co. (Canada) Inc.

DS POUR EXPEDITION SEULEMENT. VOIR FRACTURE
JR LE POID EXACT FRACTURE. SVP SIGNER ET
ER LA COPIE DU CHAUFFEUR POUR RECEPTION DU
TERIALET, SI VERIFIE, CERTIFICAT D'ANALYSE.

PTION - ITEM 2

TERMES ET CONDITIONS
DE VENTESDESABEU DES GARANTIES ET
RESTRICTION DE RESPONSABILITE
AU VERSO

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

QTE/UNITE COM-ORDERED

PCES/PO COM-ORD

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. S-P

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

INSTRUCTIONS (CONT'D.)

ENT-WHS

PTION - ITEM 3

ES DIFFÉRENCES CU COMMAGES DOIVENT ÊTRE INDQUÉS
LA COPIE REQUILVRAISON ET LA FEUILLE D'EMBALLAGE ET
É PAR LE CHAUFFEUR ET LE CLIENT. UNE COPIE DE CE REQU
ENT INDQUÉ DCIT ÊTRE SOUMIS DANS LES 10 JOURS
SQU'UN CRÉDIT EST REQUIS.

INSTRUCTIONS

COULÉE INFO-HEAT INFO QTE-QTY

QTE/UNITE COM-ORDERED

PCES/PO COM-ORD

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PO EXP. S-P

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

INSTRUCTIONS (CONT'D.)

ENT-WHS

(LETTRE MOULÉE)-NAME (PRINT ONLY)

J PAR-RECEIVED BY

DATE REQU-
DATE RECEIVED

RECEIVED LIVRAISON - DELIVERY RECEIPT

T-082 P007/010 F-406

514-695-3281

FROM-metax castle

29-11-07 09:57

AMAG rolling GmbH

AMAG
rollingAbnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate - mill certificate

AMAG rolling GmbH

Zertifiziert nach / certified to ISO/TS 16949, EN 9100, ISO 14001

Nr.: 85431828 01 / 1

Rev. 0

Seite / page: 1 von / of 1

Datum / date: 2007 10 10

Auftraggeber / customer: Castle, A M & Co (Inc) + Castle Metals 3400 N Wolf Rd USA-60131 FRANKLIN PARK, IL Warenempfänger / consignee: Castle, A M & Co (Inc) + Castle Metals 3400 N Wolf Rd Endkunde, Bestell-Nr. / Your cust., ord. no.:	Bestell Nr. / order no.: 01-84708
	Datum / date: 2007 08 06
	Auftragsbest. Nr. / order confirm. no.: 575917
	Datum / date: 2007 08 07
	Lieferschein Nr. / delivery note: 85431828
	Datum / date: 2007 10 16
	Akkreditiv Nr. / letter of credit no.:

Produkt/product	Bedingungen/terms
Form / form: plates, stretched	Techn. Lieferbedingungen / techn. spec.:
Werkstoff / material: 6061	ASTM B 209-04, AMS-QQ-A-250/11-97,
Zustand / temper: T651	ASME SB-209-04
Dim. / dim: [inch]: 2,000x48,50x144,50	Sondervorschrift / special terms:
Kundenartikel-Nr / customer article no.: 8641	

AB-Pos. ord.-Pos.	BNr/Los/Teillos Lot/No./Part	Guss Nr. cast no.	Werkstoff material	Kollo packno.	Gewicht netto weight net	Stk. pcs.
01	16296/01/00	01/0024261/7	6061	5759170001	4197,531 lbs	3
01	16296/01/00	01/0024261/7	6061	5759170002	1404,321 lbs	1

Chemische Zusammensetzung / chemical composition: [%] Gewichtsanteile / weight proportion											
Guss Nr. / cast no.	AMAG designation	Al	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
01/0024261/7	6061	97,38	0,64	0,47	0,22	0,12	0,9	0,16	0,01	0,03	0,05

Zugversuch / Tensile test									
BNr/Los/TL Lot/No./Part	Zustand temper	Richtung direction	Tests		Rm [ksi]	Rp0.2 [ksi]	A2" [%]		
16296/01	T651	LT	6	Min	47,0	38,3	16		
16296/01	T651	LT		Max	47,6	39,3	17		

Bemerkungen / notes
Herstellerland: Österreich / goods origin: The goods are of Austrian origin. Material erfüllt auch die mechanischen Eigenschaften von AMS 4027M, ist aber nicht gestempelt. / Material meets also the mechanical properties of AMS 4027M, but not marked.

Es wird bestätigt, dass die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellung entspricht.
 We hereby certify that the material described above has been tested and complies with the terms of the order contract

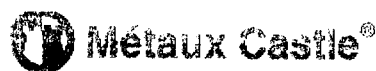
Werkstoffverständiger / factory specialist	E-Mail / e-mail
Josef Klampfer	j.klampfer@amag.at

Maschinell erstellt - Gültig ohne Unterschrift / Automated - valid without being signed

AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria - www.amag.at

CASTLE METALS CORP
 DATE RCVD 10/30/07
 IAC 2004
 APPROVED BY

354236 452481 01



A.M. CASTLE & Co. (Canada) Inc.

EXPEDIE 27 NOV 2002

POIDS TOTAL DE L'EMBALLAGE B/L NO.

RB

QUISION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO.		COMPTES/ACC. VEND. SLS TERR.		EXPEDIE PAR-SHIP VIA		NO. COM. CRI. NO.		POIDS TOTAL DE L'EMBALLAGE B/L NO.	
		3009		91037 200 40		FRAGILE (PPD) MANITOULIN		354236			
EUR-PURCHASING AGENT		TELEPHONE		H/C TAXE		REGION LIVRAISON-DEL ZONE		F.A.B.-F.O.B.		BILL	
MMA MANITULIN		410 600-2336		5 6		1 C/C		PREPAID		NO. FEVILE/EMBALLAGE-B/L NUMBER	
A-SHIP TO:		VENDU A-SOLD TO:		INFORMATION CREDIT-CREDIT INFORMATION		ROUTE					
		DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7		REC SEE FRANCE STATUS		01-NL-11/20 31-NL-11/20					
ACTIONS/LIVRAISON-DELIVERY		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)							
Q-K64235											

OPTION - ITEM 1		QTE/UNITE COM-ORDERED		POIDS COM.-WT. ORDERED	
5000 PLATE 6061-T651 ALUM 7.00" X 6.50" BLUE		50 PCS		453	
CERTIFICAT DE CONFORMITE		BALLOTS-BUNDLES		POIDS EXP.-WT. SHIPPED	
See Packing Slip for English Certificate of Conformance		1 50		453	
I. Castle & Co. (Canada) Inc. certifie que le material fourni pres ce document rencontrera et est conforme aux specifications du produit(s) descript(s) ci-contre.		FORME-SHAPE		I.A.C.	
A.M. Castle & Co. (Canada) Inc.				8641	
IDS FOUR EXPEDITION SEULEMENT. VOIR FRACTURE UR LE POID EXACT FRACTURE. SVP SIGNER ET TER LA COPIE DU CHAUFFEUR POUR RECEPTION DU TERIAL ET, SI VERIFIE, CERTIFICAT D'ANALYSE.		28.64/50F			
INSTRUCTIONS		COULEE INFO-HEAT INFO QTE-QTY		ENT-WHS	
TOL: +.060/- .000		16296-01-00		4	
THICKNESS TOL: +.060/- .000					
GRAIN TO RUN ALONG 45°					
PRIOR DIST/ORD: 01 452481		INSTRUCTIONS (CONT'D.)			
		50 x 7.00 x 6.50			

OPTION - ITEM 2		QTE/UNITE COM-ORDERED		POIDS COM.-WT. ORDERED	
TERMES ET CONDITIONS DE VENTES					
DESABEU DES GARANTIES ET RESTRICTION DE RESPONSABILITE AU VERSO		BALLOTS-BUNDLES		POIDS EXP.-WT. SHIPPED	
		FORME-SHAPE		I.A.C.	
		INSTRUCTIONS (CONT'D.)		ENT-WHS	

OPTION - ITEM 3		QTE/UNITE COM-ORDERED		POIDS COM.-WT. ORDERED	
LES DIFFERENCES CU DOMMAGES DOIVENT ETRE INDIQUEES LA COPIE RECU/LIVRAISON ET LA FEVILE D'EMBALLAGE ET E PAR LE CHAUFFEUR ET LE CLIENT. UNE COPIE DE CE RECU ENT INDIQUE DOIT ETRE SOUMIS DANS LES 10 JOURS OQU'UN CREDIT EST REQUIS.					
INSTRUCTIONS		COULEE INFO-HEAT INFO QTE-QTY		ENT-WHS	
		INSTRUCTIONS (CONT'D.)			

(L'ETRE MOULEE)-NAME (PRINT ONLY)

U PAR-RECEIVED BY

DATE RECU-
DATE RECEIVED

T-082 P009/010 P-406

514-695-3281

29-11-07 09:57 FROM-metalex castle

AMAG rolling GmbH
Abnahmeprüfzeugnis 3.1 (EN 10204)
Inspection certificate -- mill certificate

AMAG rolling GmbH

Zertifiziert nach / certified to ISO/TS 16949, EN 9100, ISO 14001

Nr.: 85431828 01 / 1

Rev. 0

Seite / page: 1 von / of 1

Datum / date: 2007 10 10

Auftraggeber / customer: Castle, A M & Co (Inc) + Castle Metals 3400 N Wolf Rd USA-60131 FRANKLIN PARK, IL Wareneempfänger / consignee: Castle, A M & Co (Inc) + Castle Metals 3400 N Wolf Rd Endkunde, Bestell-Nr. / Your cust., ord. no.:	Bestell Nr. / order no.: 01-84708 Datum / date: 2007 08 06
	Auftragsbest. Nr. / order confirm. no.: 575917 Datum / date: 2007 08 07
	Lieferschein Nr. / delivery note: 85431828 Datum / date: 2007 10 18
	Akkreditiv Nr. / letter of credit no.:

Produkt/product	Bedingungen/terms
Form / form: plates, stretched Werkstoff / material: 6061 Zustand / temper: T651 Dim. / dim: (inch): 2,000x48,50x144,50 Kundenartikel-Nr / customer article no.: 8641	Techn. Lieferbedingungen / techn. spec.: ASTM B 209-04, AMS-QQ-A-250/11-97, ASME SB-209-04 Sondervorschrift / special terms:

AB-Pos. ord.-Pos.	BNr/Los/Teillos Lot/No./Part	Guss Nr. cast no.	Werkstoff material	Kolle packno.	Gewicht netto weight net	Stk. pcs.
01	16296/01/00	01/0024261/7	6061	5759170001	4197,531 lbs	3
01	16296/01/00	01/0024261/7	6061	5759170002	1404,321 lbs	1

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01/0024261/7	6061	97,38	0,64	0,47	0,22	0,12	0,9	0,18	0,01	0,03	0,05

Zugversuch / Tensile test									
BNr/Los/TL Lot/No./Part	Zustand temper	Richtung direction	Tests		Rm [ksi]	Rp0.2 [ksi]	A2" [%]		
16296/01	T651	LT	6	Min	47,0	38,3	16		
16296/01	T651	LT		Max	47,6	39,3	17		

Bemerkungen / notes

Herstellerland: Österreich / goods origin: The goods are of Austrian origin.

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We hereby certify that the material described above has been tested and complies with the terms of the order contract.

Werkssachverständiger / factory specialist	E-Mail / e-mail
Josef Klampfer	j.klampfer@amag.at

Maschinell erstellt - GÖRig ohne Unterschrift / Automated - valid without being signed

AMAG rolling GmbH, P.O. Box 32, A-5282 Ranshofen, Austria -- www.amag.at

CASTLE METALS CORP.
 DATE RCVD 10/30/07
 IAC 2004
 APPROVED BY
 10-31-07 14:26 FROM

